

5/20

SPLIT

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23016
<b>Description:</b> Frame Weldment		<b>Part Number:</b>	D3330-041
<b>Dwg:</b> D3330 Rev. A <small>PAGE 1</small> <small>RF 05.01.13</small>		<b>Qty:</b>	15 4
			Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveler	PL	04.04.15	15																																																
2	MFA	Assemble and Weld as per Dwg D3330 using D3330-041T1 <b>Pick:</b> <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr><td>1</td><td>D3330-1</td><td>Panel</td><td>B23043</td></tr> <tr><td>1</td><td>D3330-2</td><td>Panel</td><td>B23049</td></tr> <tr><td>1</td><td>D3330-3</td><td>Panel</td><td>B23050</td></tr> <tr><td>1</td><td>D3330-5</td><td>Panel</td><td>B23051</td></tr> <tr><td>1</td><td>D3330-7</td><td>Panel</td><td>B23052</td></tr> <tr><td>1</td><td>D3330-9</td><td>Panel</td><td>B23053</td></tr> <tr><td>1</td><td>D3330-11</td><td>Long Pin Bracket</td><td>B23045</td></tr> <tr><td>1</td><td>D3330-13</td><td>Short Pin Bracket</td><td>B23044</td></tr> <tr><td>1</td><td>D3330-15</td><td>Handle</td><td>B23046</td></tr> <tr><td>1</td><td>D3330-17</td><td>Handle Socket</td><td>B22262</td></tr> <tr><td>1</td><td>D3330-19</td><td>Handle Rim</td><td>B22263 B23048</td></tr> </tbody> </table> Identify as D3330-041	Qty	Part Number	Description	Batch	1	D3330-1	Panel	B23043	1	D3330-2	Panel	B23049	1	D3330-3	Panel	B23050	1	D3330-5	Panel	B23051	1	D3330-7	Panel	B23052	1	D3330-9	Panel	B23053	1	D3330-11	Long Pin Bracket	B23045	1	D3330-13	Short Pin Bracket	B23044	1	D3330-15	Handle	B23046	1	D3330-17	Handle Socket	B22262	1	D3330-19	Handle Rim	B22263 B23048			4
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3	QC5	Inspect work to Step 2	PL	05/06/13																																																	
4	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3	FL	05/06/14	4																																																
5	QC3	Inspect Powder Coat	FL	05/06/14	4																																																
6	ST	Identify and Stock	CPL	05/06/14	4																																																
7	AC	Cost/Part: 6.23	PL	05/06/15	4																																																
8	DC	Close W/O 6.23 Inspect Level 21	PL	05/06/16	4																																																

Rev	Date	Change	Revised By	Approved
A	05.01.13	New Issue	KJ/JLM	

RELEASED

05-06-13 / 3 / Add QCS for welding inspection

QC Approval

1456

05-0

W/O:		D3330-041							WORK ORDER CHANGES	
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector			
05-06-13	3	Add. QC 9 for welding. <del>                                </del>	BA	05/06/13	N/A	U	2 05-06-13			

[illegible]

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

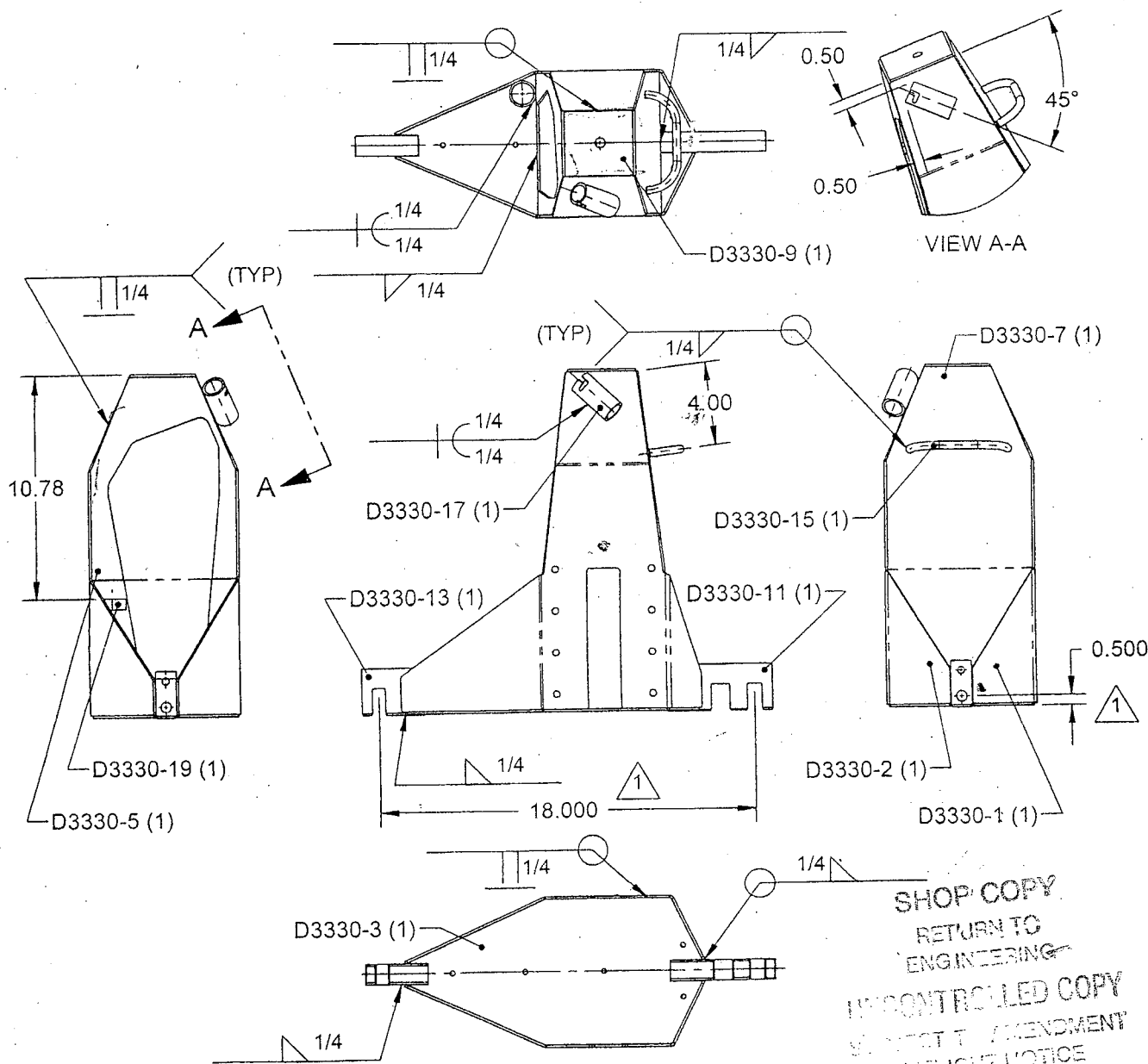
**NOTE:** Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 13	APPROVED	DRAWING NO. D3330	REV. B SHEET 1 OF 9
DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:8
A	04.12.16	NEW ISSUE	
B	05.02.26	REDESIGN	

PRELIMINARY ISSUE



### D3330-041 FRAME WELDMENT

#### NOTES:

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

SHOP COPY  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 23016

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